

Work Order ID 50975

July 28, 2009 1:52:59 PM



Page 1

Item ID: D2512

Accept



Setup Start



Revision ID: E

Item Name: Basket Lid 205/350

Stop



Start Date: 7/30/09

Start Qty: 1.00



Cust Item ID:

Required Date: 8/07/09

Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2512

Rev E

100



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512
2-Cut (4) D2236 From D3166-3
3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305
4-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

SAD 09-07-30

SH 09/08/05

(1x)

110



QC

Quality Control

QC9- Inspect visual per QS1004- Fusion Welds

0.00

Memo

0.00

AD 09-08-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50975

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Page 2

Item ID: D2512

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Item Name: Basket Lid 205/350

Start Date: 7/30/09

Start Qty: 1.00



Cust Item ID:

Required Date: 8/07/09

Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

=> S o r l o s l o c

10

6

A. 10/10/09

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

APRESSURE WASH X

0.00

09-08-06 @ JV

Memo

1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat

Powder Coating

1ST COAT:

START TIME: 10:00AM

OVEN TEMPERATURE: 400°F

FINISH TIME: 10:30AM

2ND COAT:

START TIME: 10:45AM

OVEN TEMPERATURE: 400°F

FINISH TIME: 11:15AM

M112260

09-08-06 (X) JV

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____








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Work Order ID 50975

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Item ID: D2512	Accept		Setup	Start	
Revision ID: E				Stop	
Item Name: Basket Lid 205/350					
Start Date: 7/30/09	Start Qty: 1.00		Cust Item ID:		
Required Date: 8/07/09	Req'd Qty: 1.00		Customer:		
Reference:					
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start
	QC:	Date:	SPC (Y/N):	Date:	Stop
					
					

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140  HandFinish Hand Finishing	HandFinishing <i>M111283.</i> Memo <i>M110907.</i> Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4 Batch <i>M112106</i>	0.00 0.00							
150  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							<i>BR 09-08-6 (1)</i> <i>(FD) 8</i>
160  Packaging Packaging	Identify as per dwg & Stock Location: Memo	0.00 0.00							<i>APP 50973</i> <i>9/8/14 KDS</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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July 28, 2009 1:52:59 PM

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Revision ID: E

Stop



Item Name: Basket Lid 205/350

Start Date: 7/30/09

Start Qty: 1.00



Cust Item ID:

Required Date: 8/07/09

Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*5097512**MF 09-08-10*

W/O:		WORK ORDER CHANGES					
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Picklist Print

July 28, 2009 1:52:58 PM

Page 1/3

Work Order ID: 50975

Parent Item: D2512RevE

Parent Item Name: Basket Lid 205/350

Comments:

Start Date: 7/30/09

Required Date: 8/07/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2232-1RevC		Manufactured	No			100	Each	24.0000	2.0000			

Basket Hinge

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2	
48230	2	
Main Warehouse		
WA	22	
50896	22	

D2327-1RevD

Manufactured No

100

Each

8.0000

2.0000

Spacer Bushing

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	8	
46325	8	

D2506RevF

Manufactured No

100

Each

4.0000

1.0000

Label Plate

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	4	
44275	1	
50027	3	

2x 09/08/05

2x 09/08/05

2x 09/08/05

W/O:		WORK ORDER CHANGES					
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Page 2/3

Work Order ID: 50975



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 7/30/09

Required Date: 8/07/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1 Mounting Bracket		Manufactured	No			100	Each	7.0000	2.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

B 50072

2 24 09/08/05

ST

15

46086

2

48428

13

D3166-3RevA1

Manufactured No.

100

Each

7.8105

1.0000



Basket Hoop

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

8.747336842

50033

2.74733684

50618

6

1 SAA 09-07-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3 13

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Parent Item Name: Basket Lid 205/350

Comments:

Start Date: 7/30/09

Required Date: 8/07/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased	No			100	sf	320.4235	18.0000			
Expanded Metal Flat SS												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT 320.4235065

108152 90

110134 6.7

110292 14.4

110629 14.41

110861 21.18

110992 0.58

111444 17.79

111630 9.15

111956 6.335517

112147 139.877989

18.00 SAA 09-07-20 ①

M304TS0.750W.065

Purchased

No

100 f

247.7759 45.8741

304 SQ Tube .75x.75x.065W

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT 247.7759137

111148 0.484

111432 0.44

111885 1.5682

112051 7.3691E-05

112263 245.28364

45.8741 SAA 09-07-20

July 28, 2009 1:52:59 PM

Shop Packet Print

Page 3

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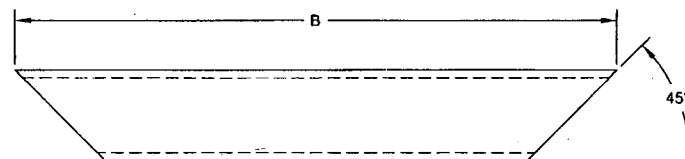
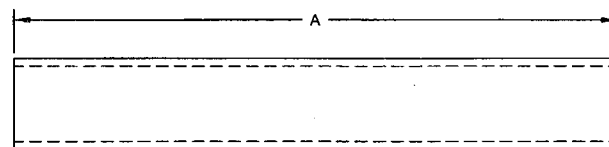
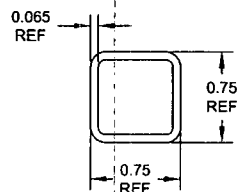
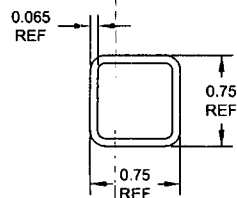
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PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

W/O
50975




RELEASED
08-08-21-117

E

D2512-1/-3/-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

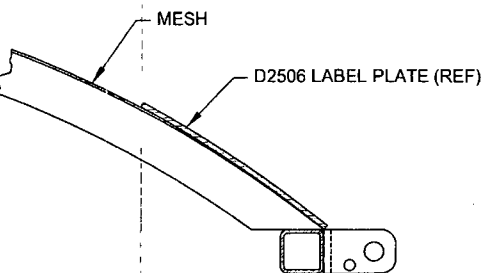
W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

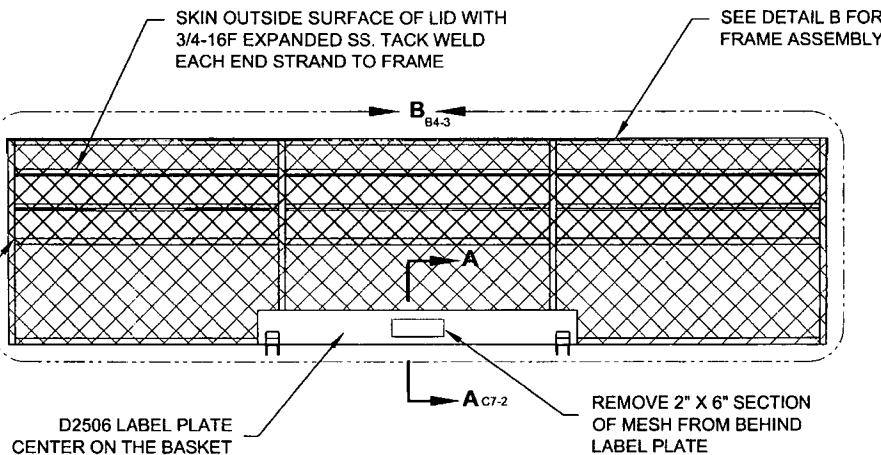
NOTE: Date & initial all entries



SECTION A-A
(ROTATED 90° CCW)

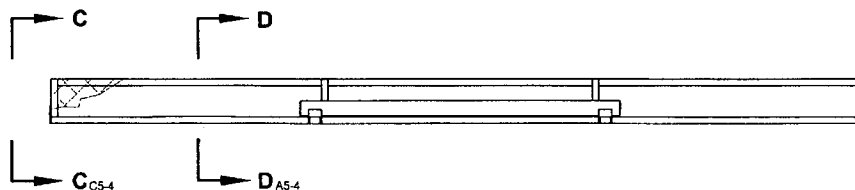
FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED





D2512 BASKET LID ASSEMBLY NOTES:

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004



RELEASED
08.06.17

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
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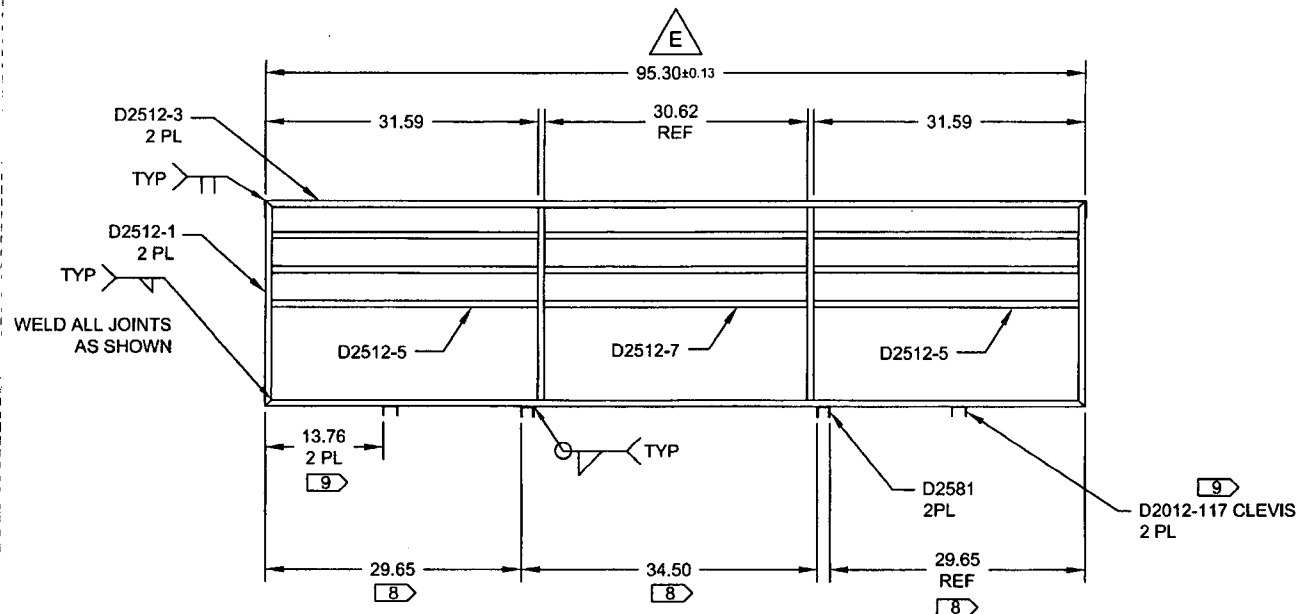
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

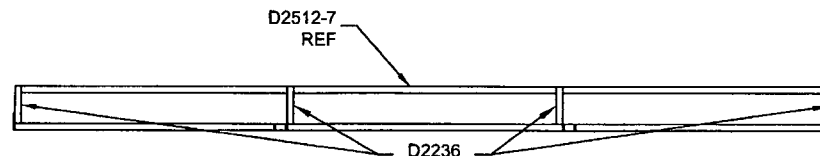
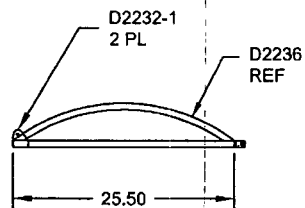
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DETAIL B C3-2
FRAMEWORK ONLY SHOWN FOR CLARITY



NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
- 9) FOR D130-701-041 ONLY

RELEASED
08-06-17

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. E
MFG. APPR.	15	D2512	SHEET 3 OF 4
APPROVED	10	TITLE	SCALE
DE APPR.	11	BASKET LID ASSEMBLY (350/212)	NTS
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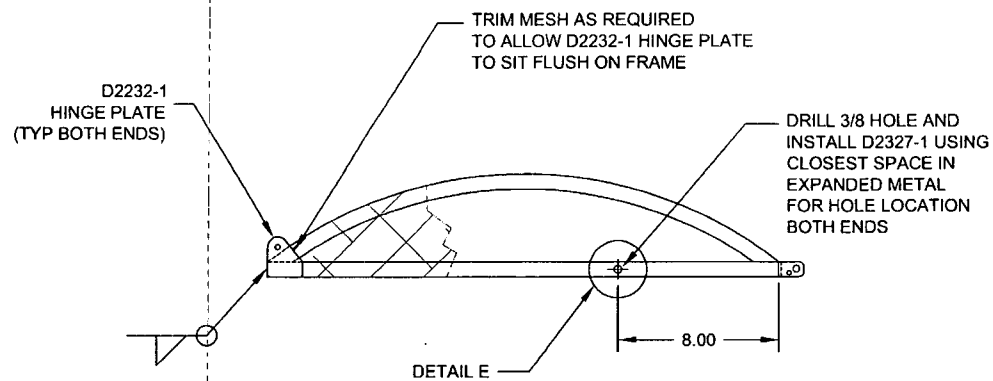
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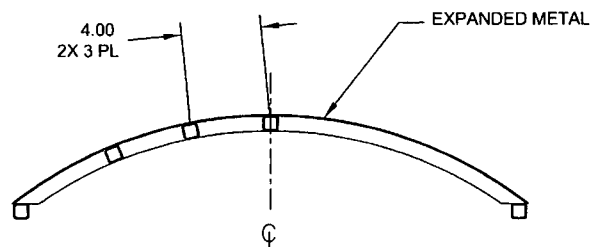
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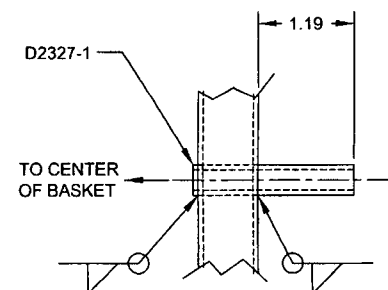
8 7 6 5 4 3 2 1



VIEW C-C SIMILAR BOTH END RIBS A5-2







SECTION D-D SAME BOTH CENTER RIBS A4-2



DETAIL E C6-4

RELEASED
08.06.17

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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8 7 6 5 4 3 2 1

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